

# Work Order ID 53550

November 9, 2009 10:01:52 AM



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Item ID:	D3838-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	09/11/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>BH</u>	Date:	<u>09-11-9</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100  
 Large Fab 0.00  
 Large Fab Memo 0.00  
 Large Fab 1- cut D3838-1 and D3838-3 rib as per dwg D3838  
 2- remove identification markings  
 3- deburr

Cpl 09 11 13

110  
 QC5- Inspect part completeness to step on W/O 0.00  
 QC Memo 0.00  
 Quality Control

⇒ 807/11/12

QC1

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Item ID: D3838-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Large Fab	0.00							
	Large Fab								
	Large Fab								
	Memo	0.00							
	1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 A/R ER316 S.S. Rod Batch: <u>M 108775</u> 2- c'sink hole as per dwg 3- grind weld flush where indicated on dwg D3838 4- weld D3759-1 bushing as per dwg D3838 5- grind bushing weld flush as per dwg dwg D3838 6- deburr hole if necessary								
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
	Quality Control								

SP 09 11 17 (2x)

Pl 09 11 18

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Item ID: D3838-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	27 S or 16/18			24 2	/		
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>W4</u>  Memo	0.00 0.00	SAD 09-11-19			12			
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							09/11/19 [Signature]

W 09.11.19

# Picklist Print

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Work Order ID: 53550



Parent Item: D3838-041RevA



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 09/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	607.5273	2.1720			
304 SQ Tube .75x.75x.065W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

113082

600

Main Warehouse

WA

7.5272947

112398

7.5272947

2.1720

D3759-1RevA

Manufactured No



Bushing

120

Each

30.0000

2.0000



SAD 09-11-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

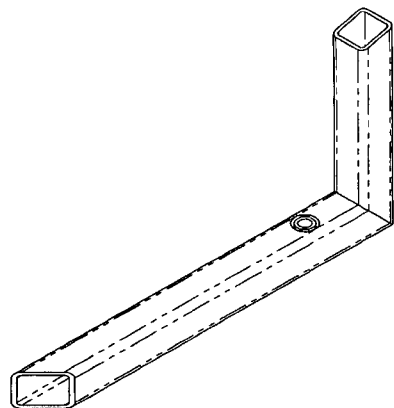
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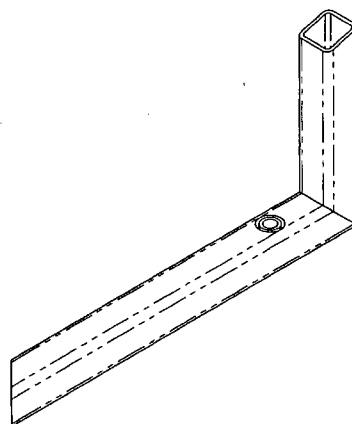
51473

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2



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

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SUBJECT TO  
WITH  
WORK

NO. 53550  
B-09-11-9

**RELEASED**  
08/11/12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.54 lbs

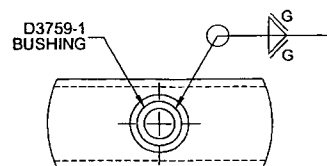
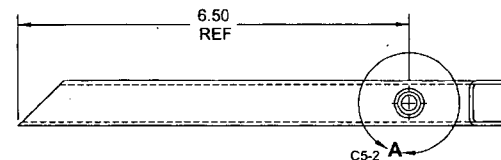
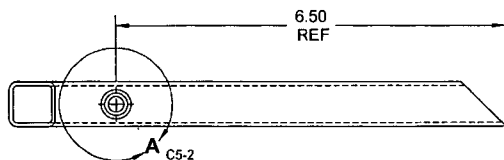
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DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.08			

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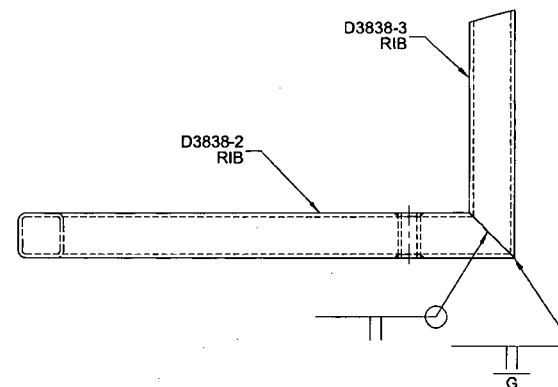
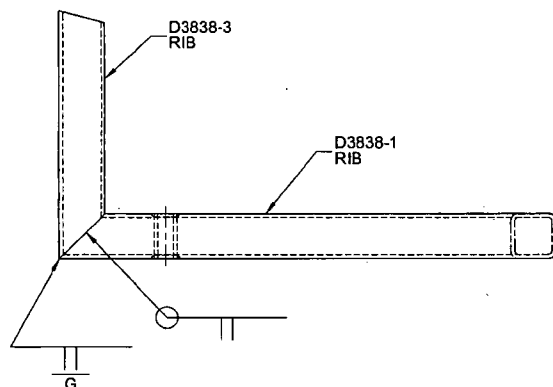
DRAWING NO. **D3838** REV. A SHEET 1 OF 3

TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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**DETAIL A**  
D2-2  
D7-2 SCALE 2X



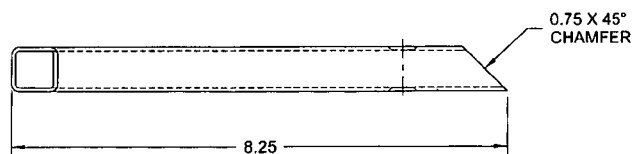
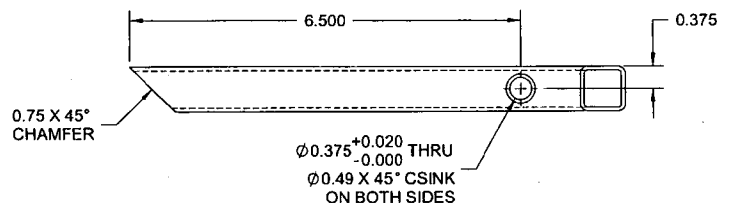
**D3838-041 RIB ASSY (BASKET LID, LH)**

**D3838-042 RIB ASSY (BASKET LID, LH)**

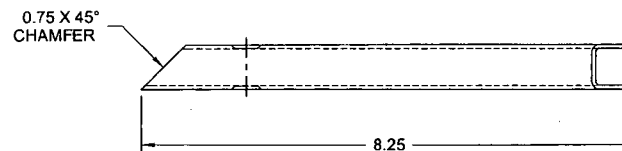
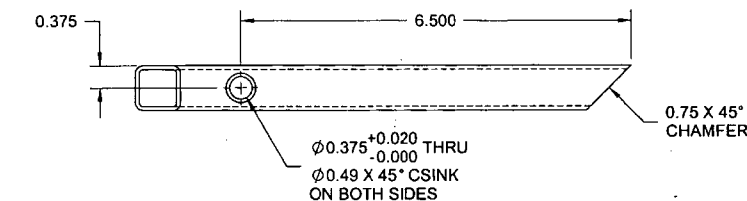
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APPROVED		<b>RIB ASSY (BASKET LID)</b>	SCALE
DE APPR.			NTS
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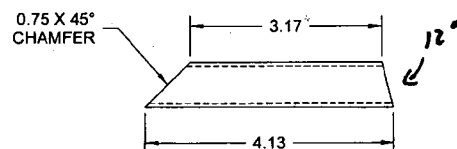
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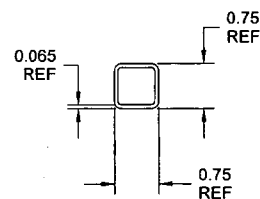
**D3838-1 RIB**



**D3838-2 RIB**



**D3838-3 RIB**



**TYPICAL SECTION VIEW**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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